

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014028**Date Inspected:** 14-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW welding of weld joint ED1-STSA4-6-123M-1-81 located on PCMK east tower, strut. Welder was identified as 040655. QC was identified as ZPMC CWI Yu Dong Ping (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2112.

SMAW welding of weld joint ED1-STSA4-6-123M-1-55 located on PCMK east tower, strut. Welder was identified as 206189. QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2112.

SMAW welding of weld joint ED1-STSA4-6-123M-1-34 located on PCMK east tower, strut. Welder was identified as 041271. QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2112.

SMAW welding of weld joint ED1-STSA4-6-123M-1-35 located on PCMK east tower, strut. Welder was identified as 251194. QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2112.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SMAW welding of weld joint ED1-STSA4-10-119M-1-10A located on PCMK east tower, strut. Welder was identified as 046769. QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2212-TC-U5b.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW visual testing repair welding of weld joint SSD1-TL5-1B/F-2B located on PCMK south tower, lift 5. Welder was identified as 0502893. QC was identified as ZPMC CWI Li Lin (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-485-SMAW-3G(3F)-repair.

FCAW repair welding of weld joint ED1-A27B/E-39 located on PCMK east tower, base shear plate assembly. Welder was identified as 053869. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-345-FCAW-1G(1F)-repair.

FCAW repair welding of weld joint ND1-A28B/B-50 located on PCMK north tower, base shear plate assembly, face A. Welder was identified as 040533. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-345-FCAW-1G(1F)-repair. QC2 informed this QA Inspector that the above 2 welds on the base shear plate assemblies were being performed to straighten to T-joint because the angle to the plate to which it was attached was out of tolerance.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Dawson, Paul	QA Reviewer
